

# Work Order ID 81735

\*81735\*

Page 1

March-16-12 3:17:15 PM

Item ID: D3688-7 Accept \*N9000040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: STUD  
 Start Date: 16/03/2012 Start Qty: 5.00 \*5\* Cust Item ID:  
 Required Date: 23/04/2012 Req'd Qty: 5.00 \*5\* Customer:  
 Reference:

Approvals: Process Plan: MLJ Date: 12/03/19 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3688	Rev <u>B</u>								
100	BAND SAW	0.00				5			
*100*									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	***DO NOT USE CHOP SAW****								
110	DOOSAN LATHE	0.00				5			
*110*									
Doosan	Memo	0.00							
Doosan Lathe	1-Turn as per Folio FA729 Rev: <u>11</u> & Dwg D3688 Rev: <u>C</u> Deburr per dwg D3688 3-Check .625" bore with DT9530 GO/NO GO Gauge								
160	QC2- Inspect parts off machine FAI/FAIB	0.00				5			
*160*									
QC	Memo	0.00							
Quality Control									

FA: 08

SA 12/6/29

SA Re 12.6.30

SA Re 12.6.30

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 81735****\*81735\***

Page 2

March-16-12 3:17:15 PM

Item ID: D3688-7 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: STUD  
Start Date: 16/03/2012 Start Qty: 5.00 **\*5\*** Cust Item ID:  
Required Date: 23/04/2012 Req'd Qty: 5.00 **\*5\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

170

QC8- Inspect parts - second check

0.00

**\*170\***

QC

Memo

0.00

*CHK 12/07/03**5 0*

Quality Control

100% CHECK,CHECK ALL DIMENSIONS AND THREAD FIT

180

PURCHASING

0.00

**\*180\***

Purchasing

Memo

0.00

*CL 12/07/09 (5)*

Purchasing

Issue P/O: 17380 LPI Per ASTM 1417 LEVEL  
2Certificate of conformaty is required

190

Receive &amp; Inspect for Damage &amp; Mat'l Certs

0.00

**\*190\***

Packaging

Memo

0.00

*14/2/2 (5)*

Packaging

Ensure certificate of conformity is attached

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

**\*81735\***

March-16-12 3:17:15 PM

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**\*5\***

**\*5\***

**Reference:**

Run Start \*NR1\*

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Insp.  
Stamp**

## Quality Control

0.00

## Packaging

0.00

## Quality Control

Qty	Qty	Number	Stamp
5			ml 12.07.09
5			SA 12/02/09
OK		12/7/10	
			MUF 12-09-09

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

March-16-12 3:17:19 PM

Page 1

Work Order ID: 81735

\*81735\*

Parent Item: D3688-7

\*D3688-7\*

Parent Item Name: STUD

Start Date: 16/03/2012

Required Date: 23/04/2012

Start Qty: 5.00

Required Qty: 5.00

## Comments:

Rev:A New Issue 08-01-29 JLM Verified By:EC  
IPP Rev:B Material Change 09-01-07 JLM Verified By:EC  
IPP Rev:C Added note on Step 2 09-01-26 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M174PH-H900R1.000

Purchased

No

100

f

45.2000

1.0871

5.721579

\*M174PH-H900R1 000\*

\*\*

SL 12/6/29

17-4SS H900 ROUND BAR 1.00

## Location

## Loc Qty

## Loc Code

MAT030

45.2

117445

21.2

120767

24

121918

4.5 ft

W/O:		WORK ORDER CHANGES					
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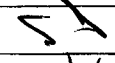
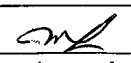




DART AEROSPACE LTD		Work Order:	81735
Description: Stud		Part Number:	D3688-7
Inspection Dwg: D3688	Rev: C	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.508	+/-0.010	.510	/			
0.438	+0.004/-0.000	.442	/			
1.42	+0.000/-0.03	1.410	/			
118°	0.5°	118°	/			
R0.03	+/-0.030	R03	/			
0.07 Ref	+/-0.030	.07	/			
90°	0.5°	90°	/			
Ø0.189	+0.005/-0.001	.190	/			
1.025	+0.000/-0.010	1.020	/			
Ø0.659	+0.000/-0.015	.657	/			
9.624	+/-0.015	9.630	/			
2.90	+/-0.030	2.90	/			
3/4-16UNF-2A	N/A	2A	/			
0.075 x 45°	+/-0.010 x 0.5°	.075 x 45	/			
0.445	+0.000/-0.010	.440	/			
Ø0.189	+0.005/-0.001	.190	/			

Measured by: 	Audited by: 	Prototype Approval:	N/A
Date: 12/6/29	Date: 12/07/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.11	New Issue	KJ	
B	09.11.04	Dwg Rev updated	KJ 	

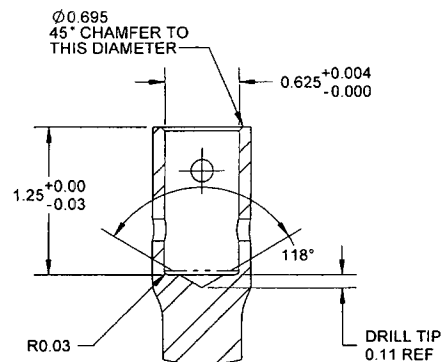
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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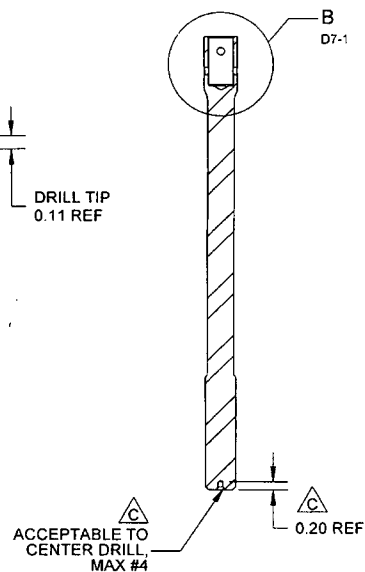
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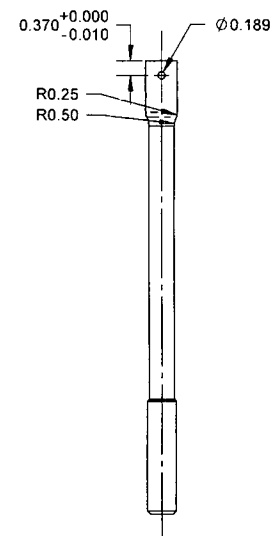
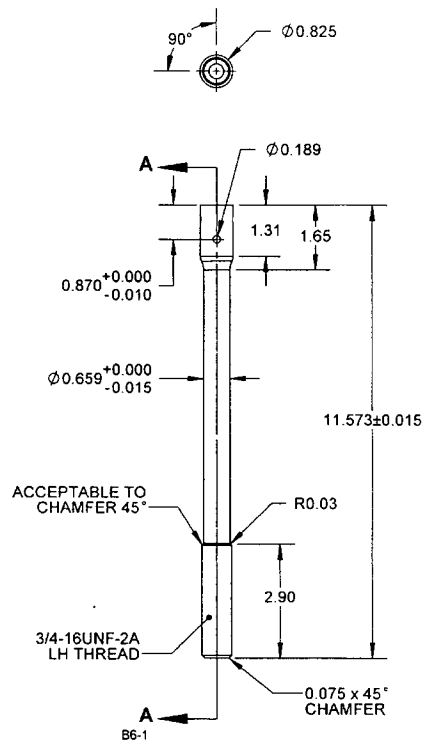
NOTE: Date & initial all entries



**DETAIL B**  
SCALE 3X  
D6-1



**SECTION A-A**  
D4-1



**RELEASED**  
2009-09-22

**NOTES:**

- 1) MATERIAL: 17-4PH STAINLESS STEEL ROUND BAR PER AMS 5643 H-900 CONDITION
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.24 lb
- 8) LPI PER QSI 038 4.1.1 (ASTM E1417 LEVEL 2)

**D3688-1 STUD**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
8/17/35 MLC

C	0.20 WAS 0.16 (ZN B5-1, B5-2, B6-3, B5-4); CENTER DRILL #4 WAS CENTER DRILL #2 (ZN B6-1, B6-2, B6-3, B6-4); UPDATE NOTE 8 TO REF QSI (ZN A8-1, A8-2, A8-3, A8-4)	RF	09.09.09
B	CHANGE TO 17-4PH H-900 (ZN A8-1, A8-2, A8-3, A4-4); REDUCE LENGTH ON D3688-1 FROM 12.073 TO 11.573 (ZN C3-1) BASED ON PROTOTYPE INSTALL; 0.695 WAS 0.665 (ZN D8-1, D8-2, D8-3); 0.508 WAS 0.478 (ZN D8-4); REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	06.05.22
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	92	DRAWING NO.	REV. C
MFG. APPR.	21	D3688	SHEET 1 OF 4
APPROVED	140	TITLE	SCALE
DE APPR.	#	STUD	NTS
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12/03/19

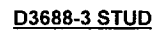
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



- 1) MATERIAL: 17-4PH STAINLESS STEEL ROUND BAR PER AMS 5643 H-900 CONDITION
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.97 lb
- 8) LPI PER QSI 038 4.1.1 (ASTM E1417 LEVEL 2)

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <b>D3688</b>  TITLE <b>STUD</b>  COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED OR FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	REV. C
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MFG. APPR.	<i>g</i>		NTS
APPROVED	<i>h</i>		
DE APPR.	<i>h</i>		
DATE	09.09.09		

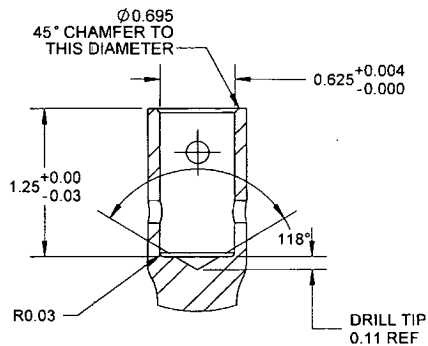
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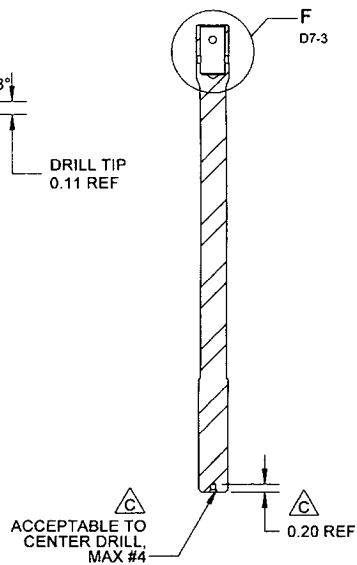
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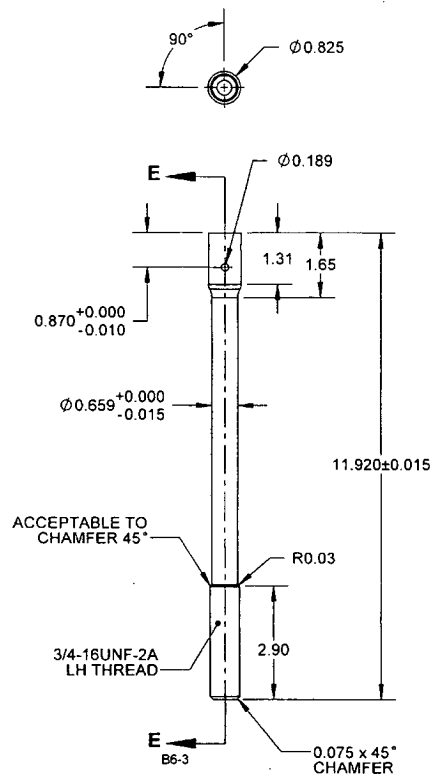
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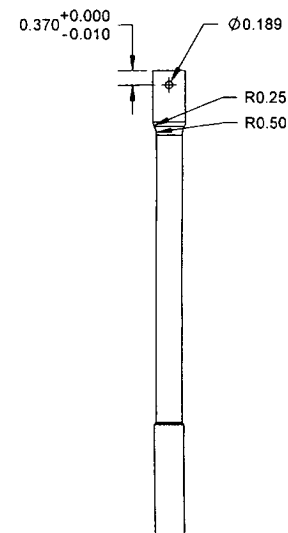
**DETAIL F**  
SCALE 3X  
D6-3



**SECTION E-E**  
D4-3



**D3688-5 STUD**



**RELEASED**  
2009-09-22

**NOTES:**

- 1) MATERIAL: 17-4PH STAINLESS STEEL ROUND BAR PER AMS 5643 H-900 CONDITION
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.26 lb
- 8) LPI PER QSI 038 4.1.1 (ASTM E1417 LEVEL 2)

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
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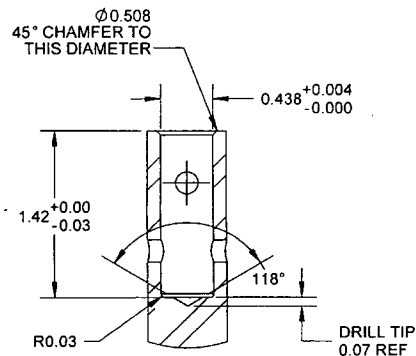
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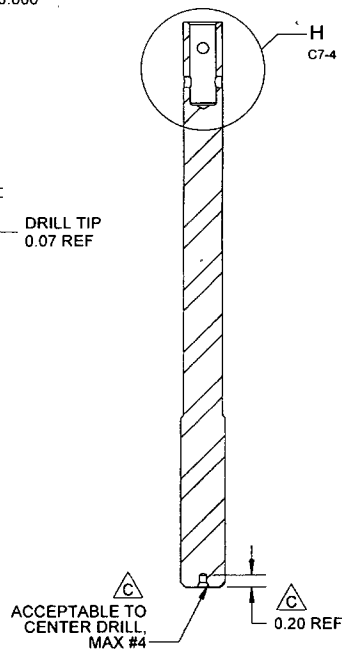
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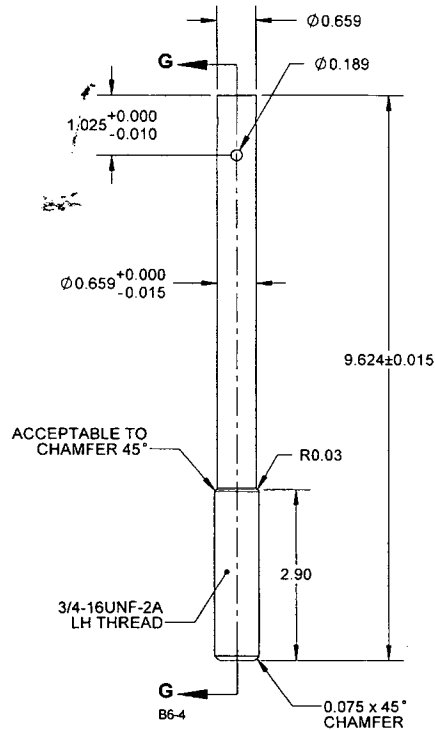




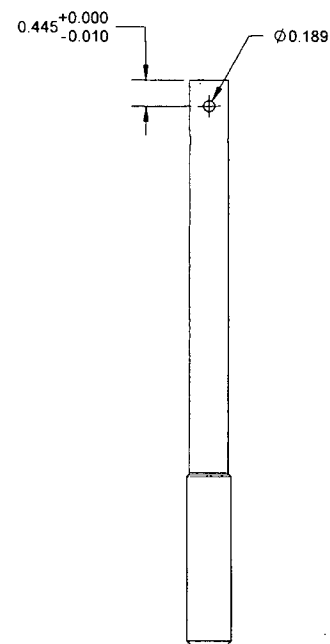
**DETAIL H**  
SCALE 2X  
D6-4



**SECTION G-G**  
D4-4



**D3688-7 STUD**



**NOTES:**

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- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.97 lb
- 8) LPI PER QSI 038 4.1.1 (ASTM E1417 LEVEL 2)

**RELEASED**  
2009-09-22

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	QJ	DRAWING NO.	REV. C
MFG. APPR.	QJ	D3688	SHEET 4 OF 4
APPROVED	AP	TITLE	SCALE
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## LIQUID PENETRANT TEST REPORT

P- 12193

CLIENT YANT AERO SPACE DATE July 4-6-2012 PAGE 1 OF 1  
ATTENTION LINDA/ANDY ACUREN JOB NO. 180-12-C0278  
ADDRESS 1270 ABELDEN ST. HAWKESBURY ON. PO/WO NO. [17380] -  
WORK LOCATION SAME  
ACCEPTANCE STD ASTM 1417/BSI-638 REV./DATE 2008  
PROJECT FPI on Machined Parts  
ITEM(S) EXAMINED RAPPEL'S, STUD'S, SLEEVE'S

JOB DESCRIPTION PROCEDURE No. LT-002 REV./DATE 2008 TECHNIQUE No. LT-002 REV./DATE 2008  
PART No. SEE RESULTS MATERIAL STAINLESS STEEL THICKNESS VARIOUS  
SCOPE A WET FLOUORESCENT LIQUID PENETRANT EXAMINATION WAS COMPLETED ON SURFACE 100 %

TEST DETAILS  
METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED  
FAMILY BRAND MAGNAFLUX BLACK LIGHT S/N 16459 ☐ OUTPUT > 1000  $\mu$ W/cm<sup>2</sup> ☐ AMBIENT < 2 fc  
PENETRANT 2LG-7 MINIMUM DWELL TIME 45 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE  
PENETRANT REMOVER H2O MINIMUM DRY TIME >10 MIN. OTHER CASINO  
DEVELOPER SADSS2 MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N 1098866 CAL DUE DATE July 14, 2012  
DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY

TEST SURFACE  
SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☒ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE METAL  
SURFACE TEMPERATURE ☐ < -4°C/ 20°F ☐ -4°C/ 20°F TO 10°C/50°F ☒ 10°C/50°F TO 52°C/125°F ☐ > 52°C/125°F

RESULTS- ☒ METRIC ☐ IMPERIAL

5	81735	STUD	✓
30	81735	" "	✓
16	83359	" "	✓
5	W.O. #	RAPPEL	✓
15	83358	SLEEVE	✓

W/ 12 07 09

## Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

## Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar location. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

## SIGNATURES

CLIENT REPRESENTATIVE Andy Sheldon PRINT ASheldon SIGNATURE DTR # E-163666  
TECHNICIAN (SIGNATURE): [Signature] REPORT REVIEWED BY:  
NAME (PRINT): [Signature] NAME INITIALS  
CGSB LEVEL 2 SNT LEVEL 2 CGSB LEVEL 2 SNT LEVEL 2  
CGSB REG. NO. 6606 CGSB REG. NO. 6606